

Date: Thursday, 2/7/2008 10:54:22 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 37283
Estimate Number : 10531
P.O. Number : Part Number : D2572
This Issue : 2/7/2008 S.O. No. : Drawing Number : D2572 REV E
Prsht Rev. : NC Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS Drawing Revision : E
Previous Run : 36323 Material :
Written By : Due Date : 2/28/2008 Qty: 12 Um: Each
Checked & Approved By : 08 02 07
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572
Ensure that grain is along 5.00" length
Batch No: 13, 138

08/02/26

(12)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 3278 Double check by: SA

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove shap edges.

08/03/01

(12)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

08/03/01

(12)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/03/01

(12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 37283

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SC 08.05.05

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BK 08.03.03

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FD 08/03/04

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-L

08/03/04

(12X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 422

8/3/5

SC

(12X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/03/06

(12)

Job Completion



2008/3/05

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 37283
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.442	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.498	3.498	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.005	8.006	8.004		
F	0.490	0.510		0.500	.502	.503	.494		
G	0.257	0.262	DT8683	0.260	0.260	0.260	.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	.377		
I	0.490	0.510		0.501	0.500	0.500	.501		
J	1.174	1.184		1.179	1.180	1.180	1.180		
K	0.558	0.578		0.570	0.568	0.570	.577		
L	1.174	1.184		1.179	1.180	1.180	1.180		
M	1.490	1.500		1.496	1.496	1.496	1.496		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.874	3.874	3.874		
P	0.115	0.135		0.125	0.126	0.123	.123		
Q	0.115	0.135		0.135	0.135	0.135	.135		
R	0.240	0.260		0.250	0.251	0.249	.250		
S	0.115	0.135		0.135	0.126	0.127	.126		
T	0.178	0.198		0.188	0.188	0.188	.188		
U	2.940	2.980		2.958	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.233	0.235	.238		
W	0.115	0.135		0.122	.126	.124	.123		
X	0.307	0.312		0.310	.308	.310	.310		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		0.371	.362	.366	.365		
AA	0.470	0.530		0.500	0.500	0.500	.500		
AB	0.615	0.635		0.625	.630	.631	.631		
AC	0.053	0.073		0.063	0.063	0.063	.063		
AD	0.240	0.260		0.245	0.244	0.245	.245		
AE	1.375	1.395		1.387	1.388	1.387	1.388		
AF	0.115	0.135		0.135	.135	.135	.135		
AG	0.240	0.280		0.256	0.259	0.250	.255		
AH	0.240	0.260		0.247	0.243	0.245	.248		
AI	2.000	2.020		2.000	2.001	2.000	2.001		
AJ	0.023	0.043		.030	.030	.030	.030		
Accept/Reject									

Measured by: <i>gmk / SA</i>
Date: 02/02/28

Audited by: <i>RF</i>
Date: 04.03.03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	37283
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.442	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.002		
F	0.490	0.510		.503	.503	.504	0.507		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.378		
I	0.490	0.510		.502	.502	.501	0.501		
J	1.174	1.184		1.179	1.179	1.178	1.178		
K	0.558	0.578		.574	.574	.575	0.570		
L	1.174	1.184		1.179	1.179	1.178	1.178		
M	1.490	1.500		1.493	1.493	1.493	1.494		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.871		
P	0.115	0.135		.123	.123	.123	.124		
Q	0.115	0.135		.135	.135	.135	0.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.124	.125	.124	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.958		
V	0.230	0.250		.238	.238	.239	0.239		
W	0.115	0.135		.120	.121	.121	.126		
X	0.307	0.312		.309	.309	.309	.304		
Y	0.760	0.765		.763	.762	.766	.766		
Z	0.352	0.372		.367	.367	.361	0.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	0.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.240	.240		
AE	1.375	1.395		1.388	1.389	1.387	1.388		
AF	0.115	0.135		.135	.135	.135	0.135		
AG	0.240	0.280		.255	.255	.255	.250		
AH	0.240	0.260		.250	.250	.250	0.245		
AI	2.000	2.020		2.001	2.001	2.001	2.001		
AJ	0.023	0.043		.030	.030	.033	.033		
Accept/Reject									

Measured by:	SA
Date:	08/02/28

Audited by:	FE
Date:	08-03-03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	37283
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

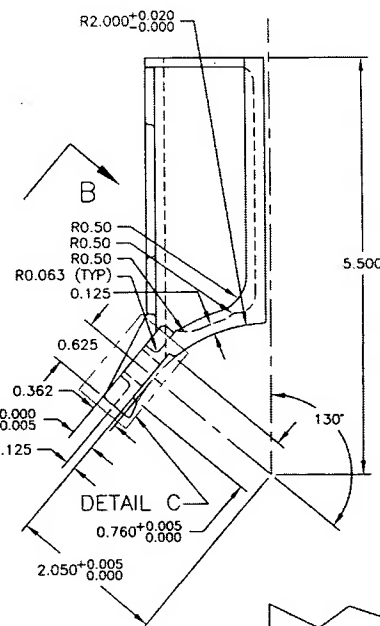
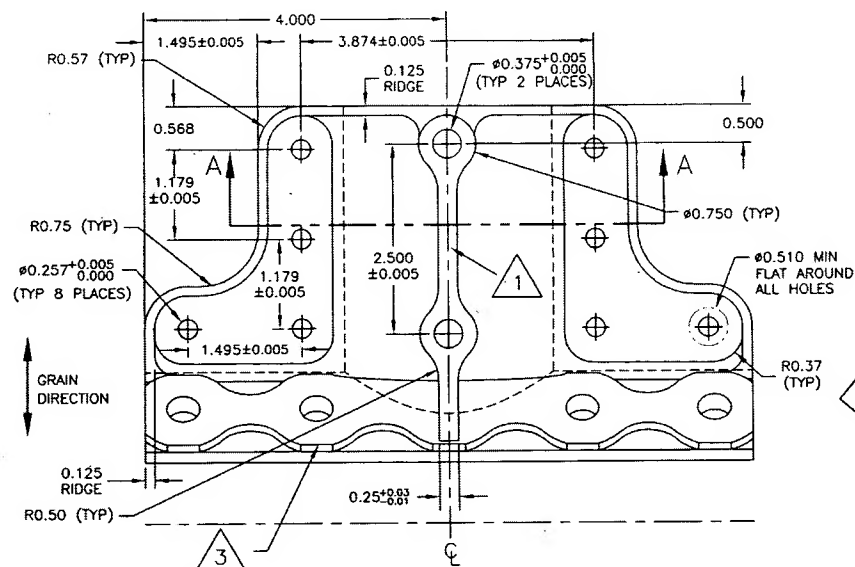
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.442	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.506	3.506	3.500	3.506		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.000	8.000		
F	0.490	0.510		1.501	.507	.502	.500		
G	0.257	0.262	DT8683	.248	0.259	.259	.259		
H	0.375	0.380	DT8684	.377	0.378	.378	.378		
I	0.490	0.510		.506	0.506	.506	.506		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.576	0.576	.568	.568		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.493	1.494	1.494	1.494		
N	2.495	2.505		2.506	2.506	2.500	2.506		
O	3.869	3.879		3.871	3.871	3.871	3.871		
P	0.115	0.135		.123	0.123	.124	.123		
Q	0.115	0.135		.135	0.135	.135	.135		
R	0.240	0.260		.250	0.249	.250	.249		
S	0.115	0.135		.118	0.126	.126	.124		
T	0.178	0.198		.188	0.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.959		
V	0.230	0.250		.238	0.238	.236	.234		
W	0.115	0.135		.125	.120	.124	.124		
X	0.307	0.312		.309	.309	.309	.309		
Y	0.760	0.765		.761	.760	.760	.760		
Z	0.352	0.372		.366	.366	.362	.362		
AA	0.470	0.530		.500	0.500	.500	.500		
AB	0.615	0.635		.625	.628	.627	.629		
AC	0.053	0.073		.063	0.063	.063	.063		
AD	0.240	0.260		.241	0.247	.246	.244		
AE	1.375	1.395		1.390	1.390	1.386	1.387		
AF	0.115	0.135		.135	0.135	.135	.135		
AG	0.240	0.280		.250	0.250	.244	.245		
AH	0.240	0.260		.246	0.247	.244	.244		
AI	2.000	2.020		2.002	2.001	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	9m
Date:	08/03/01

Audited by:	RG
Date:	08.05.05






Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

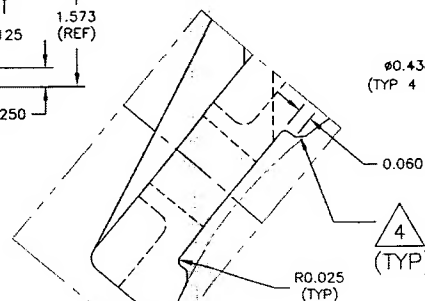
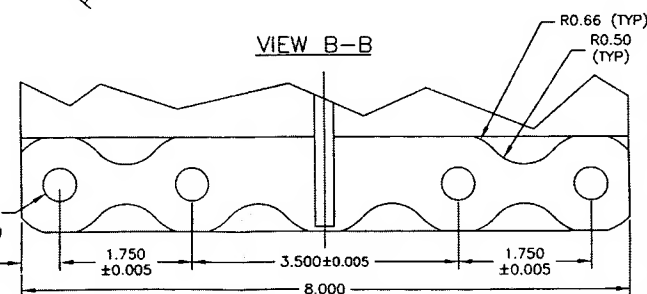
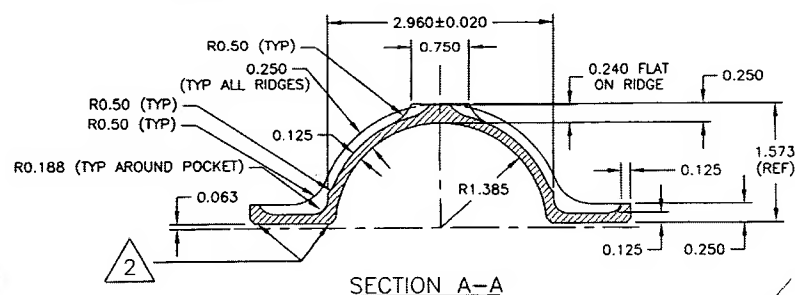
05.12.06



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED


- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063 x 45° ALL AROUND |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C)  |



DETAIL C
SCALE 2:1

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OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
CHECKED #		APPROVED #
DATE 05.07.13		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA DRAWING NO. D2572 TITLE INNER FWD SADDLE
		REV. 5 SHEET 1 OF 2
		SCALE 2:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37283

